

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013086**Date Inspected:** 19-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Wuzhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG TRIAL ASSEMBLY

This QA Inspector Randomly observed the following work in progress:

SEGMENT: 7AE-Panel Point(PP)#49.

Shielded Metal Arc Welding (SMAW) welding of weld joint CA033-005. Welder is identified as 066413. ZPMC Quality Control (QC) is identified as Mr.Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2212-TC-U4b-FCM-1.

SEGMENT: 7BE-PP#49.

Shielded Metal Arc Welding (SMAW) welding of weld joint CA036-005. Welder is identified as 066413. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2212-TC-U4b-FCM-1.

SEGMENT: 7BE-7CE

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SEGMENT: 7CE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CA040-004. Welder is identified as 066028. ZPMC Quality Control (QC) is identified as Mr. Sun Bai Zheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F) FCM-Repair-1 .The repair welding was been performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR 1227 and American Bridge/Fluor (AB/F) UT report # UT-7E-032 dated: 02/28/2010.

SEGMENT: 7AE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG034-007. Welder is identified as 048659. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-1G (1F) FCM-Repair-1 .The repair welding was been performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR 1211 Rev. 1 and American Bridge/Fluor (AB/F) UT report # UT-7E-029R1 dated: 03/15/2010.

SEGMENT: 7AE-7BE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint OBE7B-003. Welder is identified as 054467. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-1G (1F) FCM-Repair-1 .The repair welding was been performed against the Welding Repair Report (WRR) No: B-WR 11147 and ZPMC UT report # UT-B787-UT-11764 dated: 03/17/2010.

SEGMENT: 7AE PP#48.

This QA Inspector observed American Bridge/Fluor (AB/F) QA Inspector Mr.He Zhi Shun was performing Magnetic Particle Testing (MT) for Side panel T Rib Holdback fillet welds at SEGMENT: 7AE PP#48. The attached photographs provide additional detail.

SEGMENT: 7AW- PP#48.

This QA Inspector observed ZPMC MT Technician Mr.Liu Zhang Min was performing MT on base metal temporary jig removed repaired area for Deck panel at SEGMENT: 7AW- PP#48. The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
